

**ABSTRACT**

Spirally wound single-ply web products having a chemical additive applied to at least one surface exhibit desirable roll bulk characteristics and softness properties. The rolled products can be made from a single-ply tissue web formed according to various processes. Once formed, the web is subjected to a shear-calendering device that increases the Fuzz-On-Edge properties of the web and preserves the bulk of the web when wound. The shear-calendered web then has a chemical additive applied to at least one surface by a non-compressive application method helping to maintain the Fuzz-On-Edge properties of the web.